

Date: Monday, 12/01/2009 2:30:22 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BACK FRAME ASSEMBLY
<b>Job Number</b> : 44559	
<b>Estimate Number</b> : 11129	
<b>P.O. Number</b> :	<b>Part Number</b> : D3017041 <i>GY</i>
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3017 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44558	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 10/02/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>JUD 09.01.12</i>	
<b>Comment</b> : Est. A 01.09.19 New issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M4130NT0750W049	4130 RD Tube .750 x.049W
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**Comment:** Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s)

4130 Tube .750 OD x.049W

Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall

Batch: *M11105 X 88" A10302 A116 1045*

*EL 9-6-16*

2.0	D30177	Lug
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**Comment:** Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Lug

Pick:

Qty	Part Number	Description	Batch
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3	D3017-7	Lug	<i>B38567</i>
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*EL 9-6-16 (3)*

3.0	D301711	cap
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap

batch: *B42354*

*EL 9-6-17*

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Bend tube as per dwg D3017

3-Drill holes in D3017-5 Using DT8622

4-Deburr

*EL 9-6-17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 12/01/2009 2:30:22 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 44559

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

A/R 4130 Rod Batch: M102226

6-Drill holes in back frame using back panel drill jig DT8621 (D3017-5 holes) EL 9-6-17 (P10)

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

BE 9-6-23 (1)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/06/23 (X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:30AM

OVEN TEMPERATURE: 320°F

FINISH TIME: 12:00pm

HP 09-06-24 (X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-24 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SA

EP

09/06/24

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/24 (A)

Job Completion



U 09-06-24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
090618	4.6	Add a note to 4.6 to drill per yellow 3017-5 holes.  per change					

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
090618	4.6	Employee drilled the 1 holes by mistake: not the 4 correct - 5 holes.  RC: 1st timer on the same.		Fill the 4 incorrect holes with weld per 051004 & Drill flush Rod M 102226 Drill correct - 5 holes 4 places.	 9-6-22			

NOTE: Date & initial all entries

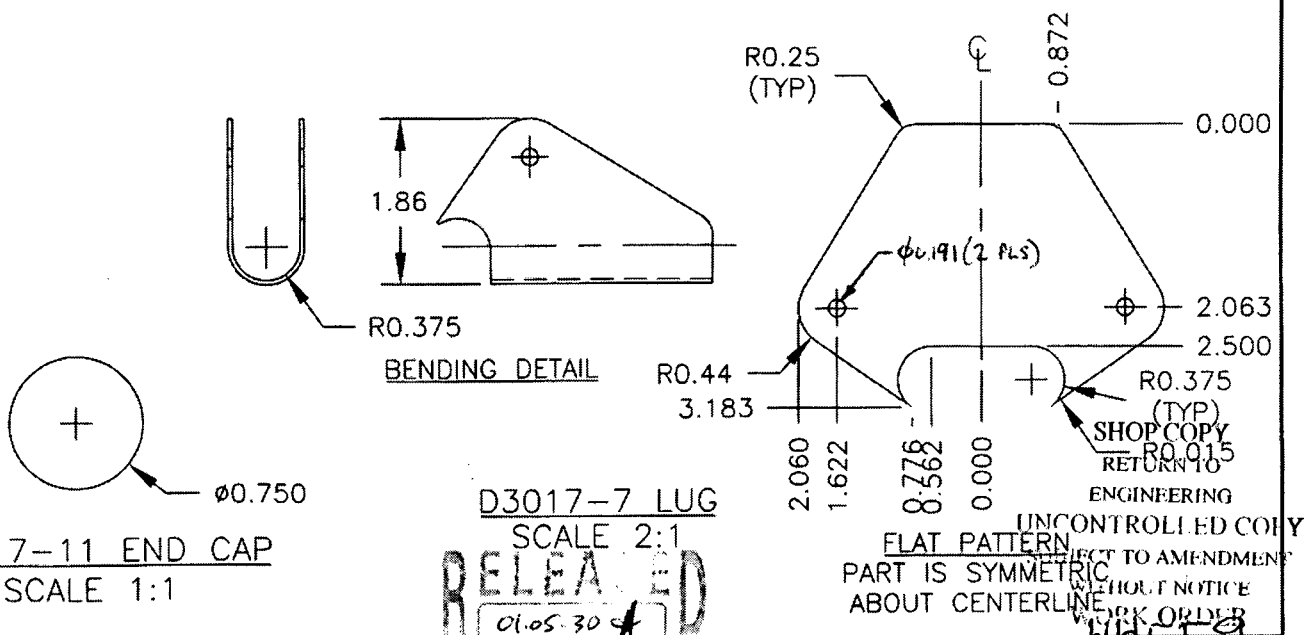


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE 01.05.18		TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

#### NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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